

Date: Wednesday, 4/19/2006 7:36:53 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 26708		
Estimate Number	: 11480		
P.O. Number	: <i>N/A</i>	Part Number	: D31452
This Issue	: 4/19/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3145 REV B
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 5/5/2006 Qty: 10 Um: Each
Checked & Approved By	: <i>06.04.19</i>		
Comment	: Est. A 03-02-28 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"
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Comment: Qty.: 0.4025 f(s)/Unit Total : 4.0247 f(s)  
 6061-T6 Bar 2.0" x 2.0"  
 Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8)  
 M6061T6B2.000x2.000)  
 Batch: *M17124*

*ml 06/05/01* 16

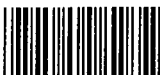
2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

*ml 06/05/01* 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine per Folio FA318 and Dwg D3145  
 Deburr and Tumble

*J.F. ml 06/05/05* (10)

4.0A	QC2	INSPECT WORK TO CURRENT STEP
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4.0B QC8

Comment: INSPECT WORK TO CURRENT STEP

*J.F. ml 06/05/05* (10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*DL 06/05/08* (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/07

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 7:36:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 26708

Part Number: D31452

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/08 (10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 4/5/8 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

man's work

DL 4/5/8 (10)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/05/08 (10)

Job Completion



2 06-02-09

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 26708
<b>Description:</b> Bracket		<b>Part Number:</b> D3145-2
<b>Inspection Dwg:</b> D3145	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.188	+/-0.010	R0.188	✓			
0.125	+/-0.010	0.128	—			
1.636	+/-0.010	1.640	—			
0.125	+/-0.010	0.123	—			
0.766	+/-0.010	0.766	✓			
0.250	+/-0.010	0.247	✓			
1.370	+/-0.010	1.366	—			
0.760	+/-0.010	0.765	—			
4.303	+/-0.010	4.290	—			
0.125	+/-0.010	0.130	—			
0.219	+/-0.010	0.222	✓			
R0.125	+/-0.010	R0.125	—			
1.960	+/-0.010	1.962	✓			
1.250	+/-0.010	1.250	✓			
0.180	+/-0.010	0.180	—			
R0.250	+/-0.010	R0.250	—			
0.240	+/-0.010	0.241	✓			
0.108	+/-0.010	0.108	—			
Ø0.221 x 0.351	+/-0.010	Ø0.223 x 0.346	✓			

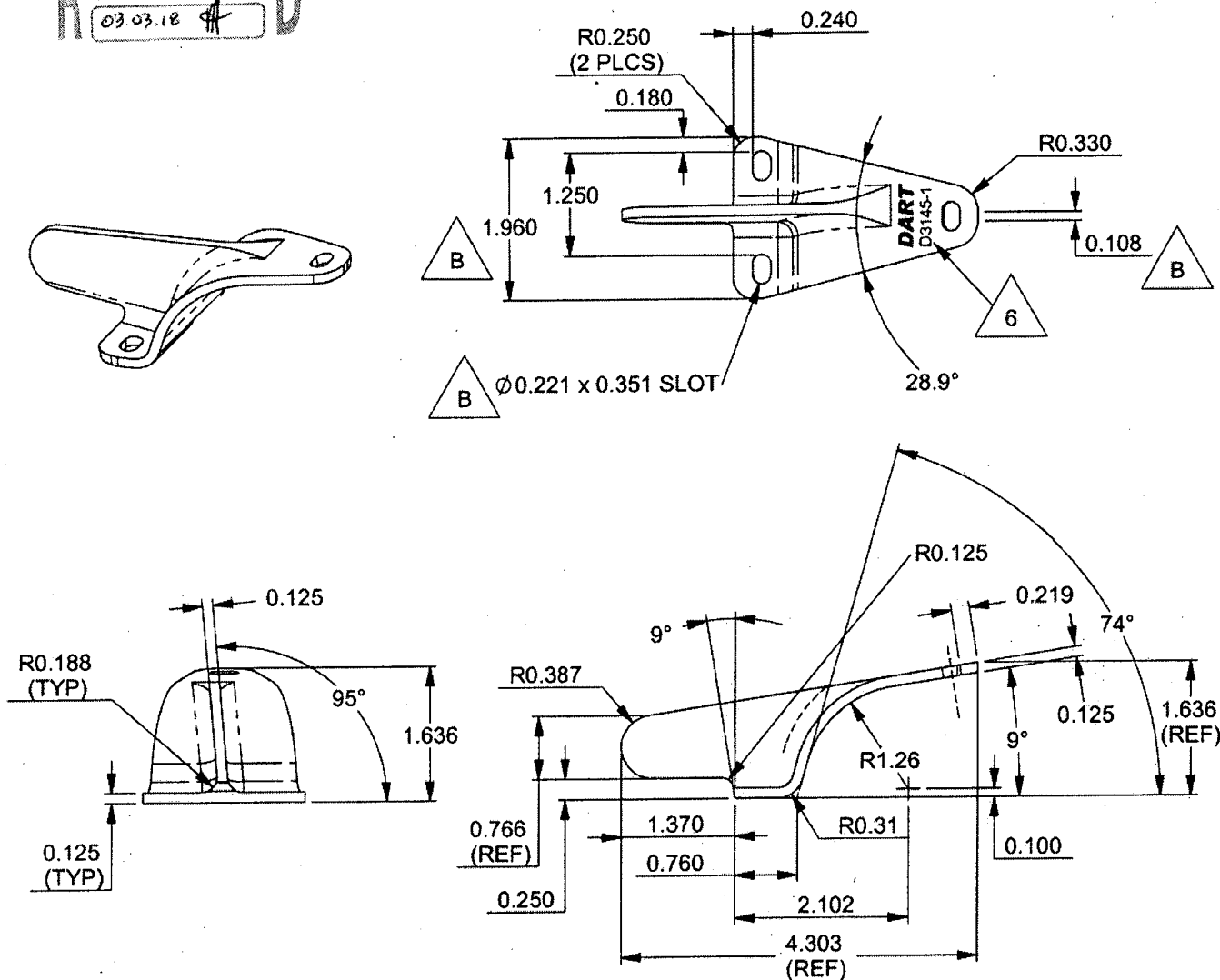
<b>Measured by:</b> [Signature]	<b>Audited by:</b> J.L	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/05/05	<b>Date:</b> 06/05/05	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM [Signature]	[Signature]



DESIGN <i>TF</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3145</b>	REV. B SHEET 1 OF 1
DATE <b>03.02.06</b>		TITLE <b>BRACKET</b>	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED  
03.03.18



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25  
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **26708**

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